

Date: Thursday, 05/02/2009 3:47:47 PM  
 User: Julie Dawson

## Process Sheet

Split

050309

for order  
of 2

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SPACEPOD FLOOR LH  
 Job Number : 45578 *1*  
 Estimate Number : 13593  
 P.O. Number : Part Number : D3798041 *BY*  
 This Issue : 05/02/2009 S.O. No. : Drawing Number : D3798 REV A  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : / / Type : SMALL / MED FAB Drawing Revision : A  
 Previous Run : Material :  
 Written By : Due Date : 28/02/2009 Qty: 4 Um: Each  
 Checked & Approved By : *JUD 09.02.06*  
 Comment : Est Rev:A 08-09-18 new issue DD verified by:ec

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6S050 6061-T6 .050 Sheet

*18 9-2-27*

Comment: Qty.: 9.2334 sf(s)/Unit Total: 36.9335 sf(s) ;  
 6061-T6 .050 Sheet *17347x3 =*  
 Batch: *110791x2 =*

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET  
 1-Cut as per Dwg D3798-1  
 Dwg Rev: *A*  
 Prog Rev: *A*

*18 9-2-27*

2-Deburr if necessary *18 9-2-27*

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE

*18 9-2-27*

Comment: INSPECT PARTS AS THEY COME OFF MACHINE  
 \*\*\*template B3798-1T1\*\*\* *AT9432*

4.0 QC8 SECOND CHECK

*09-03-09 (4)**P70*

Comment: SECOND CHECK  
 \*\*\*template B3798-1T1\*\*\* *AT9432*

5.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1  
 Chemical Conversion Coat as per QSI 005 4.1

*MD/ F2**(M)**09/03/09*

W/O: 45578		EST: 13593		WORK ORDER CHANGES			
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
090303	4.0	Took 7 for template DT9432 Powder cost average & ident. by		090203 09.06.23	1		

Part No: D3798-041 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 05/02/2009 3:47:47 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD FLOOR LH

Job Number: 45578

Part Number: D3798041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



m105642



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

START TIME:

8:00

OVEN TEMPERATURE:

320°

FINISH TIME:

8:30

FL 09/03/04

(4)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

OK 09-03-4

(4)

8.0

D37983

Spacepod Floor Foam



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Spacepod Floor Foam

B45720(x2) B46895

774090623

FF 09-03-09

(2)

9.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- install foam as per dwg D3798 using contact cement

batch: 11110907

2- trim foam if necessary

3M Scotch Grip 1357 contact cement

09-06-23

FF 09-03-09

(2)

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

N/A

See split 09-06-23

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with Dart part # using a fine point permanent marker and Stock

Location:

09/06/23

See

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/06/23

Job Completion



MF 09-06-23

W/O: 43578		EST: 13593		WORK ORDER CHANGES				
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
09.06.23	9	Use 1357 Contact Adhesive M105623 "Permanent Change"	E	09.06.23		10 09.06.23	18 09.06.23	

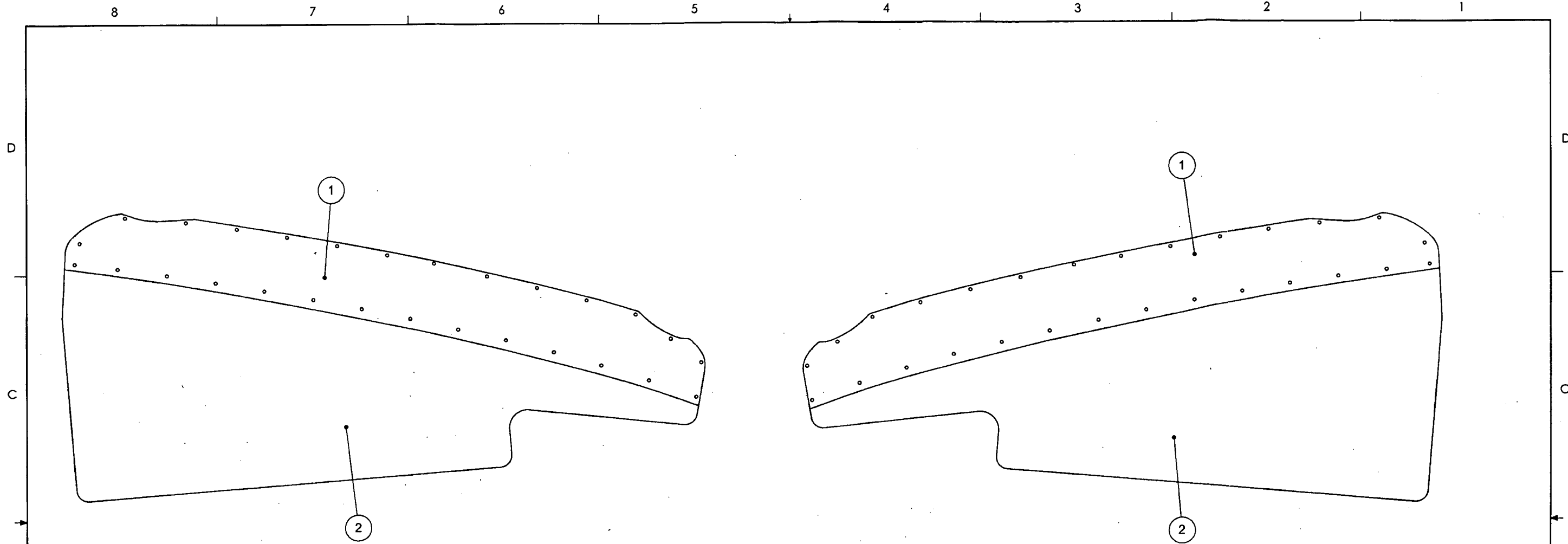
Part No: D37A8-041 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries





ITEM NO.	PART NUMBER	DESCRIPTION	QTY. -041
1	D3798-1	SPACEPOD FLOOR	1
2	D3798-3	SPACEPOD FLOOR FOAM	1

D3798-041 SPACEPOD FLOOR, LH

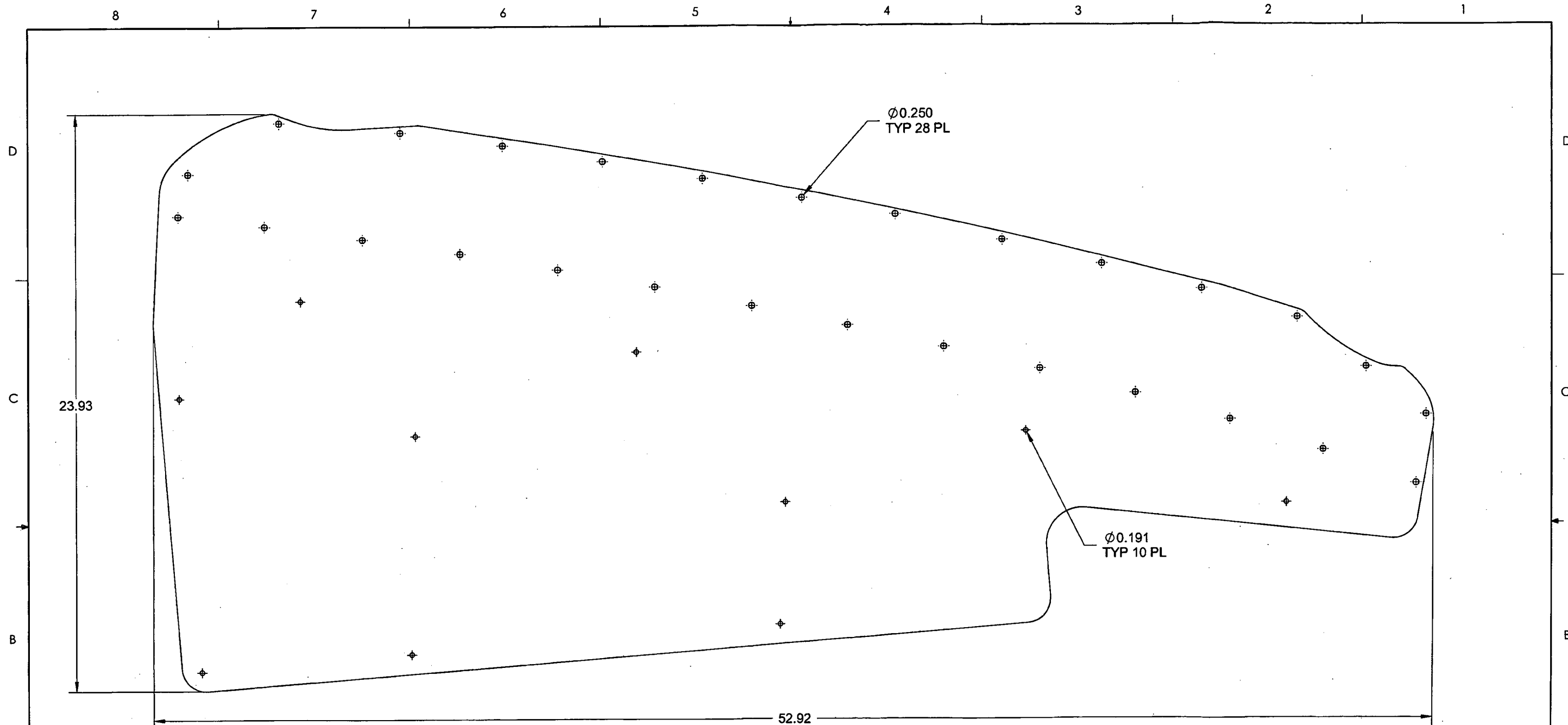
ITEM NO.	PART NUMBER	DESCRIPTION	QTY. -042
1	D3798-1	SPACEPOD FLOOR	1
2	D3798-3	SPACEPOD FLOOR FOAM	1

D3798-042 SPACEPOD FLOOR, RH

RELEASED  
09/01/13

NOTES:  
1) IDENTIFICATION: IDENTIFY WITH DART P/N D3798-041/-042 USING WHITE FINE POINT PERMANENT INK MARKER  
2) WEIGHT: D3798-041 - 4.5 lbs  
D3798-042 - 4.5 lbs  
3) INSTALL D3798-3 FOAM AS INDICATED USING CONTACT CEMENT. TRIM TO FIT

A	NEW ISSUE	BY	08.10.20
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3798	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		SPACEPOD FLOOR	NTS
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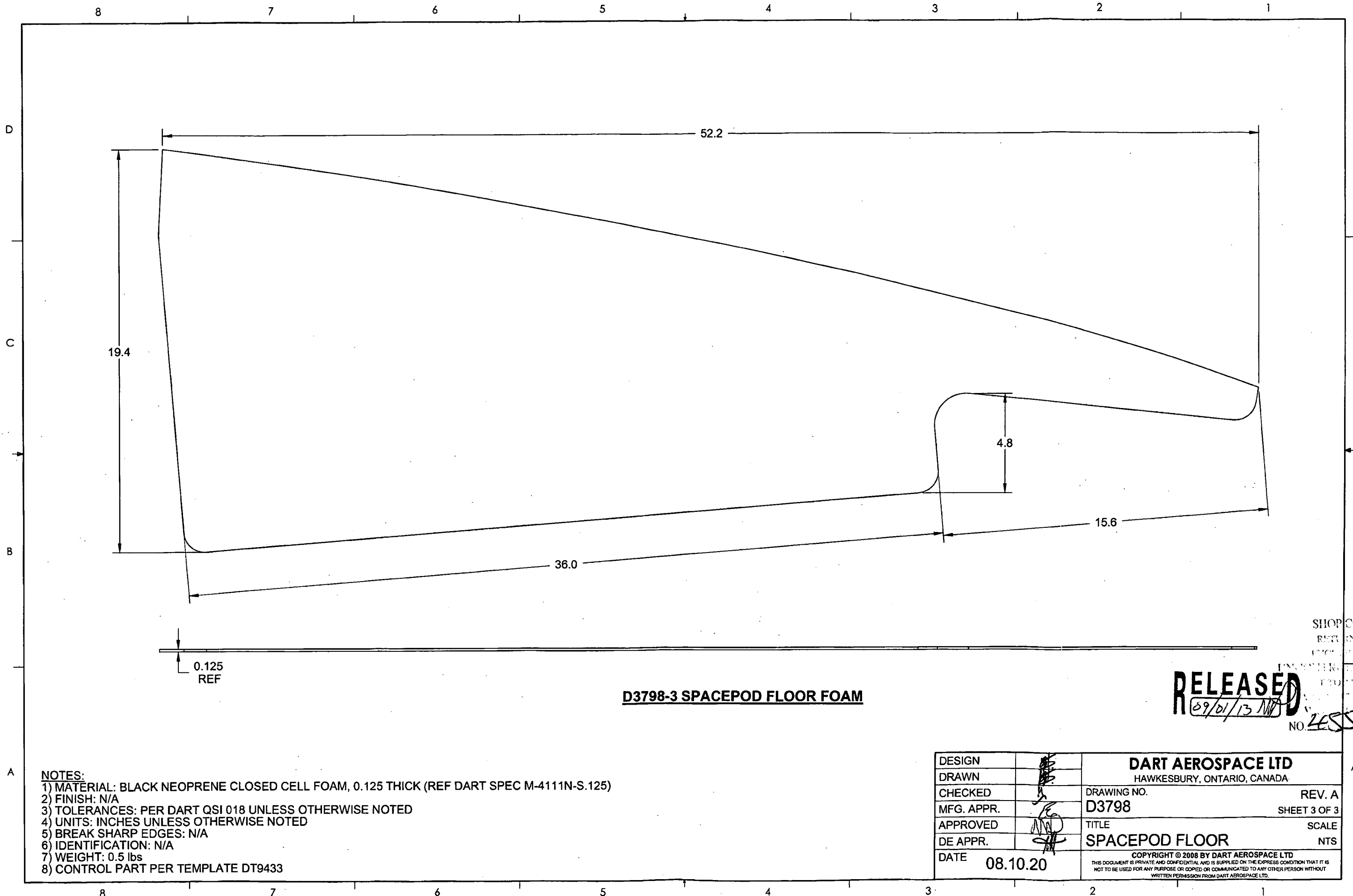
D3798-1 SPACEPOD FLOOR

RELEASED  
09/01/13

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.050 THICK PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.050)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 4.0 lbs
- 8) CONTROL PART PER TEMPLATE DT9432

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
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**D3798-3 SPACEPOD FLOOR FOAM**

- NOTES:**
- 1) MATERIAL: BLACK NEOPRENE CLOSED CELL FOAM, 0.125 THICK (REF DART SPEC M-4111N-S.125)
  - 2) FINISH: N/A
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: N/A
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 0.5 lbs
  - 8) CONTROL PART PER TEMPLATE DT9433

DESIGN		<b>DART AEROSPACE LTD</b>	
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CHECKED		DRAWING NO.	REV. A
MFG. APPR.		<b>D3798</b>	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		<b>SPACEPOD FLOOR</b>	NTS
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 09/01/13

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